

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004576**Date Inspected:** 12-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** see below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

OBG Bay 1:

The QA Inspector randomly observed 4 ZPMC welders ID Numbers 059416/059378 and 059361/062265, utilizing the Gas Metal Arc Welding (GMAW) Process in 2G/2F Positions on Gantry 2 with ZPMC Weld Procedure Specification (WPS) WPS-B-T-2342-U1(U-Rib)-4, to weld the U-Ribs to Deck Plate DP396-001, at Weld Joint (WJ) Numbers 003/004 and 007/008. The QA Inspector randomly observed ZPMC QC monitoring weld parameters. The QA Inspector also randomly monitored weld parameters and recorded them as follows: 373/380 amps, 30.2/30.8 volts (003/004) and 365/369 amps, 29.5/30.3 volts with a travel speed of 525 millimeters (mm) per minute. Weld parameters appeared to comply with contract requirements.

OBG Bay 2:

The QA Inspector randomly observed 6 Magnetic Drill Operators drilling bolt holes on various Longitudinal Stiffeners.

OBG Bay 3:

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The QA Inspector randomly observed ZPMC workers grinding side panel completed welds located on the gantry 1 table.

OBG Bay 4:

The QA Inspector performed a 10% final Visual (VT) and MT verification on the cover pass of the fillet welds on Side Panel SP486-001 welds 001 ~ 014, SP158-001 welds 013 ~ 024 and SP158-001 welds 050 ~ 061. The fillet welds attaching I-Beams to the side panel had been accepted previously by QA and QC. There appeared to be no indications and the QA Inspector signed ABF green tagging documentation.

Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Dautermann, Peter (707) 552-7715, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon,Timothy	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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